

ASAP

Split

Dart Aerospace Ltd.

Date: Monday, 10/22/2007 3:41:39 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BAR	
Job Number	35281 <u>B-2</u>		Part Number	D3197041	
Estimate Number	10390		Drawing Number	D3197 REV B	
P.O. Number	<u>N/A</u>		Project Number	N/A	
This Issue	10/22/2007	S.O. No. <u>N/A</u>	Drawing Revision	B	
Prsht Rev.	NC		Material	<u>N/A</u>	
First Issue	<u>N/A</u>		Due Date	11/5/2007	
Previous Run	30655		Qty:	12 Um: Each	
Written By			<u>8 JLM</u>		
Checked & Approved By					
Comment	Est Rev: A New Issue 05-11-08 JLM Est Rev:B As per Rev B 06-03-10 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M7075T73R1000	7075-T73 Round Bar 1" OD	
		Comment: Qty.: 2.5410 f(s)/Unit Total : 30.4920 f(s) Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD (M7075T73R1.000) Identify for D3197-1 Batch: <u>10070</u> 10/10/27	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 29.125" long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Face ends to lenght per dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197 3-Deburr	<u>SA 07.10.30</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>SA 07.10.30</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BAR
Job Number: 35281		Part Number: D3197041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	LATHE CONV.	CONVENTIONAL LATHE
Comment: CONVENTIONAL LATHE Chamfer as per Dwg D3197		SA 07.11.19
6.0	QC8	SECOND CHECK
Comment: SECOND CHECK		JULY 07-11-19
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		MJ 07-11-20 X8
8.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		BL 07-11-21 8.
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		MR. J 07/11/21
10.0	D26905	Lanyard ass'y
Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s) Pick: Qty Part Number Description Batch		B35308 X20 B30611 X4 AS 07/11/21 X8
11.0	D32421	Tag
Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s) Pick: Qty Part Number Description Batch		B30605 X2 TAG B3531 X(2) X14 AS 07/11/21 X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BAR
Job Number: 35281		Part Number: D3197041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	AN960JD10	Washer
Comment: Qty.: 6.0000 Each(s)/Unit Total : 72.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
6 AN960JD10	Washer	B105792
		AS 07/11/21 (X8)
13.0	D34893200	PIP PIN
Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
2 D3489-3-200	Pip Pin	B26207-# R26207 M507/11/21 (X8)
14.0	MS21042L3	Nut
Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
2 MS21042L3	Nut (or -3)	M104625-
		AS 07/11/21 (X8)
15.0	MS27039124	Screw
Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
2 MS27039-1-24	Screw	M100274
		AS 07/11/21 (X8)
16.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Assemble D3197-041 as per Dwg D3197		
		MF 07-11-24 (X8)
17.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
		d 07/11/26(X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/11/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11- 23	16.	Ianyard hooks Kept coming out, resqueezed all of them 5 scrap.	<u>D</u> 6SIPM	Resqueezed all of them Scrap the nonconformity Parts <u>(x5)</u>	M/F 07-11- 26	<u>D</u> 01/11/26	<u>D</u> Q5JWY	<u>D</u> 01/11/26
		D2690-5, # B 30611. R.C. malfunctions						

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 35281

Part Number: D3197041

Job Number:



Seq. #: Machine Or Operation:

Description :

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 247 C711P4

AS 07/11/26

(8)

19.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 07/11/26

(8)

Job Completion



AS 07/11/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

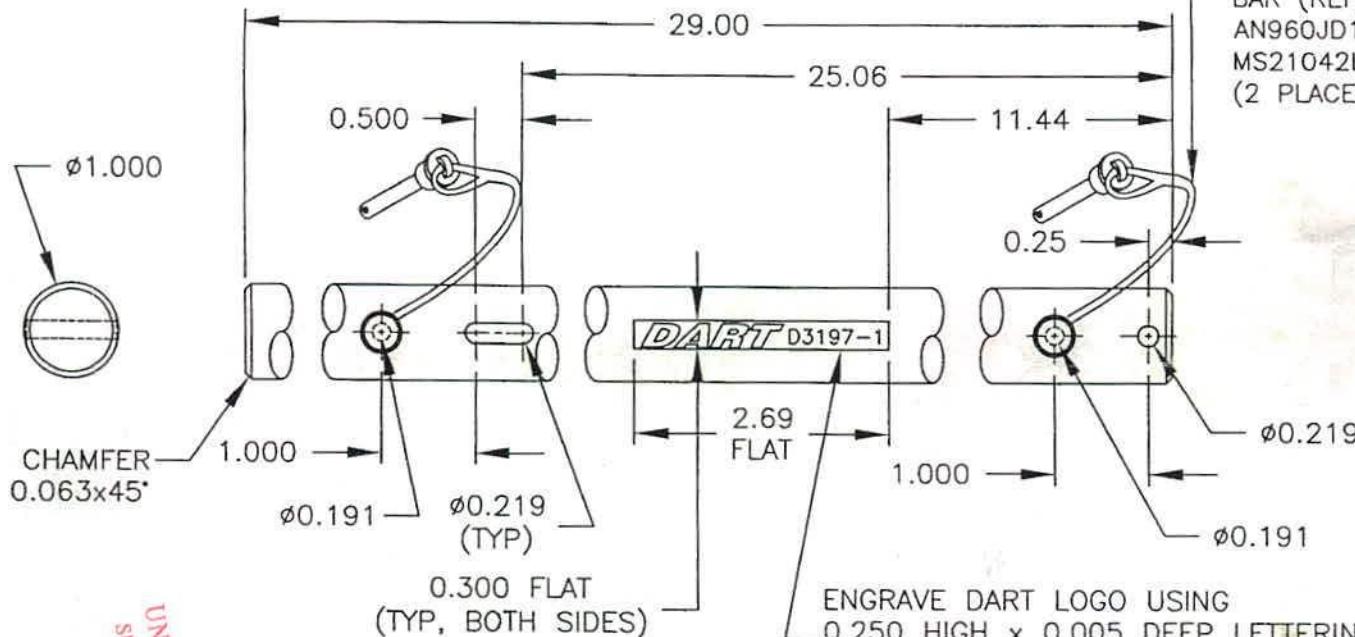
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
03.03.21
CON 93

DART

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED BY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO.
35281

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) Ø1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD	
CHECKED #	APPROVED #	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE 06.01.10		TITLE BAR	REV. B
SHEET 1 OF 1			SCALE 1:1
A		03.07.01 NEW ISSUE	
B		06.01.10 CHG PIP PIN; ADD D3242-1 TAG	

DART AEROSPACE LTD

Work Order: 35281 13

Description: Bar

Part Number: 3197-1

Inspection Dwg:

Rev:

Page 1 of

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi 1.000$		1.000	/			
29.00	$\pm .030$	29.000	/			
25.06	$\pm .030$	25.06	/			
11.44	$\pm .030$	11.44	/			
.25	$\pm .030$.250	/			
$\phi .219$	$+.005$ $-.001$	$\phi .219$	/			
$\phi .191$	$+.005$ $-.001$	$\phi .191$	/			
1.000	$\pm .010$	1.000	/			
2.69	$\pm .030$	2.690	/			
.300	$\pm .010$.310	/			
.500	$\pm .010$.500	/			
1.000	$\pm .010$	1.000	/			
$.063 \times 45^{\circ}$		$.063 \times 45^{\circ}$	/			

Meas (red by)

84

Date: 07.10.30

Audited by:

Date: 07/11/19

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	